Work Order		4243		*114	124:	3*						Page 1
Revision ID: Item Name:	O3595-063-3	on		Accept			<b>040</b>	100	<b>)*</b> s	Setup Sta	171	S1* S2*
Start Date: 1 Required Date: 1 Reference:	.7/03/2014 .7/03/2014	<b>Start Qty:</b> 20.00 <b>Req'd Qty:</b> 20.00	*20* *20*			ist Item I istomer:	D:					
Approvals:	Process Pla	in: ML5	Date: 14-03-05	Tooling:		Da	ate:	_	F	Run Sta	~! <i>\</i> J	R1*
			Date:	SPC (Y/N):		Da Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	T	ool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Revi	ision Nbr			***		·			* * * * * * * * * * * * * * * * * * *		
D3595	A											
100				0.00						***************************************		
*100* Waterjet		FLOW WATER JET  Memo		0.00					_20			Jn14.03-25
FLOW CNC Waterjet		1-Cut as per Dwg Rev:_ Prog Rev:_ 2-Deburr if r	<u>A</u> A									
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00								
*110* QC Quality Control		Мето		0.00					20	٥	_	Ju14-03-25
120		QC8- Inspect parts - seco	and check	DAS 27 0.00 \9-59					$\sim$			
*120* QC Quality Control		Memo		0.00 MBJX	, ,				$\mathfrak{X}$			

DQA:			_ Date:										`	$^{\prime\prime}$ aaa $^{\prime\prime}$
						WORK ORDER NON	-C(	ONFO	RMANCE / UI	PDATE		_		AEROSPACE
QA Closed:			Date:							١	Work Order u	pdate only	$\Box$	
Work Orde	er:					DISPOSITION				AGAINST [	DEPARTMENT	PROCESS		
	•					Rework	]		Skid-tube	Crosstube		Water Jet	$\neg$	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.		Quality
	•					Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR N	lo.ِ					Suspected Unapproved			Large Fab	Composite		Supplier		
_	······						r .				T -: -	·	<del></del>	
Root		Data	C	<b>~</b>	Desc	ription of work order update		Initial	Act		Sign &			001
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	iption	Date	Verification	+	QC Inspector
Design Doc/Data	$\dashv$												- [	
Equip/Tooling	Н													
Handling/Pre														
Material														
Operator		-												
Offset/Setup														
Process														
Supplier													ı	
Training														
Transport														
Unapproved			<u> </u>	<u></u>			Ļ					:	丄	
Landi		2	<del></del>	· · · · · · · · · · · · · · · · · · ·			FA	ULT CA	TEGORY					
Landi	_	Bending			_	<b>General</b> Bend		]/r	Program	Г	Outside Din		_	Dungarium /F a a a d
		_	ot Concer	ntric	-	BOM/Route	H	Grain	riografii	-	Over/Under		-	Pressure/Forced Set-up
	$\vdash$	Cracks	or concer	ILLIC	-	Broken/Damage/Defect	┝	Hardwa	aro	Ì	Part Incorre		_	Temperature/Cure
	$\vdash$	Crimp/Ki	nk/Ripple	/Wave	-	Burrs	H	4	ion Incomplete/Ur	ngualified	Part Lost/M			Weld
	-	Cuffs		,		Contamination	H	1 '	tions Incomplete/L	·	Part Moved	h	_	Wrong Stock Pulled
		Crushing				Countersink		-	gned/off center		Positioned			
		Heat Tre				Cut Too Short	$\vdash$	Mislab	-	Ī	Power Loss,	· · ·	$\Box$	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea		L		- L		
		Marks/Cl	hatter			Drill Holes		Off-set						
		Turning S	Sequence			Finish		Out of	Calibration					
		Wave/Tv	vist in Tub	oe		Fit/Function		Out of	Sequence					

Work Ord March-04-14 2		4243		*112	1243	*							Page 2	
Item ID: Revision ID: Item Name:	D3595-063-		The second secon	Accept	*No	300	<b>040</b>	100	)*	Setup	Start Stop	17	S1* S2*	
Start Date: Required Date Reference:	14/03/2014 : 17/03/2014	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			t Item I tomer:	D:						,	
Approvals:	Process Pla	an:	Date:	Tooling:		Da	ate:	_		Run	Start	<i>^</i> I <i>V</i> I	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>		D:	ate:	<del></del>			Stop	*N	R2*	
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Sto	ock Location: <u>LGS</u> )	Set Up/ Run Hours	To	ol ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
*120* Packaging Packaging		Мето		0.00					20			M	AR 2 6 2014	) () ()
140		OC21. Final Inspection	Work Order Paleace	0.00										

0.00

Memo

\*140\*

**Quality Control** 

MLJ 14-03-28 MLJ 14-03-28

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			WORK ORDER NON-	-C(	JNFOI	RMANCE / U		Wo	ork Order up	odate only	٦ _	AEROSPACE	
		1.0				DISPOSITION						PARTMENT	•	_1		
Work Orde	er: _					_	.			,	_		_	_		
						Rework			Skid-tube	Crosstube			Water Jet	-1 -	neering	
Part N	اo. <u> </u>					Scrap			Machining	Small Fab		1	d. Eng. Coor.	4	Quality	
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	_	Other	
NCR N	NO				_	Suspected Unapproved			Large Fab	Composite			Supplier			
Root					Desci	ription of work order update		Initial	Ac	tion		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC	Inspector	
Design																
Doc/Data	$\Box$															
Equip/Tooling	Ц		ļ													
Handling/Pre	Щ															
Material	$\Box$															
Operator	Щ	•														
Offset/Setup	Ц															
Process	Ц															
Supplier	$\dashv$		l .												4	
Training	_															
Transport	Н														:	
Unapproved			<u></u>				<u> </u>						== 1	<u> </u>		
							FAI	ULT CAT	regory							
Landii					_	General		1 ,_		ı		1	_	7	_	
	$\boldsymbol{\vdash}$	Bending			<u> </u>	Bend	<u> </u>	1	rogram			Outside Dim	<del> </del>	_	re/Forced	
	$\vdash$	Centre No	ot Concer	ntric	$\vdash$	BOM/Route	⊢	Grain				Over/Under	<u> </u>	Set-up		
	_	Cracks			-	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred	<del></del>	-	rature/Cure	
	_	Crimp/Kir	ik/Ripple	/Wave		Burrs	<u> </u>	1 '	ion Incomplete/U			Part Lost/Mi	· ·	Weld		
	-	Cuffs				Contamination	<u> </u>	4	ions Incomplete/	Unclear	_	Part Moved		Wrong	Stock Pulled	
	—	Crushing			$\vdash$	Countersink	<u> </u>	1 -	ned/off center	ļ	_	Positioned V	_	<b>7</b>		
	-	Heat Trea			-	Cut Too Short	<u> </u>	Mislabe		l		Power Loss/	Surge	Other		
	—	nspection		Tube		Drawing	<u> </u>	Misread								
	$\vdash$	Marks/Ch				Drill Holes	<u> </u>	Off-set								
		Furning S				Finish	<u> </u>	4	Calibration							
	۱ <u>۱</u> ۷	Nave/Tw	<u>ist in T</u> ub	oe		Fit/Function		Out of S	Sequence							

**Picklist Print** 

March-04-14 2:59:02 PM

Work Order ID: 114243

Parent Item:

D3595-063-395

Parent Item Name: Rubber Cushion

\*114243\*

\*D3595-063-395\*

**Start Date:** 14/03/2014

**Required Date:** 17/03/2014

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

IPP Rev:A 10.11.03 as per dwg revA DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595	,	Manufactured	No			100	sf	527.2004	0.0196 (	1)		-	
*D3595* Rubber Cushion (\$ Per Sq Fi	1)								**			Jmi	4-03-25
				<b>Location</b>		Loc Ot	<u>x</u>	Loc Code					
				MAT052		527.20	04				_		
				(	58954	23.7	07		_		_		
				8	84209	12.41	34				_		
				Ģ	94539	491.	08		2	7453	3		

DQA:			Date:											abla
		•				<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:			· · · · · · · · · · · · · · · · · · ·				W	ork Order u	odate only		
Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
	•					Rework	1		Skid-tube Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining Small Fab	-	Pro	d. Eng. Coor.	$\neg$	Quality
	•					Use-as-is	1	Therr	moforming Finishing		Rec/Sto	re/Packaging		Other
NCR <sub>.</sub> N	۱o.					Suspected Unapproved			Large Fab Composite		]	Supplier		
Root					Desci	ription of work order update	Ī	Initial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector
Design				}										
Doc/Data														
Equip/Tooling									:					
Handling/Pre														
Material				-										
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved		!												
1						**	FA	ULI CA	TEGORY					
Landi						General Bend		ارمانم ا	) no ano m	_	70	: Г		D
·	$\vdash$	Bending Centre No	ot Concor	tric		BOM/Route	⊩	Grain	Program	H	Outside Dim			Pressure/Forced
	$\vdash$	Cracks	of Concer	iti it		Broken/Damage/Defect	$\vdash$	Hardwa	ara		Over/Under Part Incorre	- H		Set-up Temperature/Cure
	$\vdash$	Crimp/Kir	ok/Pinnlo	/\/\/\	-	Burrs	$\vdash$	-}	tion Incomplete/Unqualified	-	Part Lost/Mi	- H		Weld
	$\vdash$	Cuffs	ik/ Kippie,	vvave	<u> </u>	Contamination	$\vdash$	┪ `	tions Incomplete/Unclear	$\vdash$	Part Moved	Issilig		
	$\vdash$	Crushing			$\vdash$	Countersink	$\vdash$	4	gned/off_center	$\vdash$	Positioned V	Vrong.		Wrong Stock Pulled
		Heat Trea	ıt		-	Cut Too Short	$\vdash$	Mislabe		$\vdash$	Power Loss/	· ·		Other
	$\vdash$	Inspection		Tube	$\vdash$	Drawing	$\vdash$	Misrea		_	J. 04461 2035/	Juige [		
	$\vdash$	Marks/Ch	•	. 450	<u> </u>	Drill Holes	$\vdash$	Off-set						
	<del>                                     </del>	Turning S			-	Finish		-	Calibration					
		Wave/Tw		e		Fit/Function		-1	Sequence					

DART AEROSPACE LTD	Work Order:	114243
Description: Rubber Cushion	Part Number:	D3595-063-395
Inspection Dwg: D3595 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

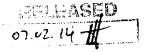
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63	+/-0.030	G-640"			U	James 5
3.95	+/-0.030	3.9562	_		U	
0.125	+/-0.010	6-640° 3.956° 0,n8°	_		V	
					<u> </u>	
AND THE PARTY OF T					<b>***</b>	
<u></u>						

Measured by:	Jm	Audited by:	12 mg		Preliminary Approval:			
Date:	14-03-25	Date:	14/26		Date:			

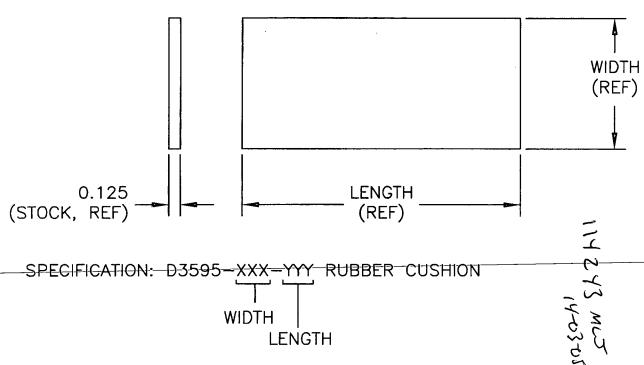
Rev	Date	Change	Revised by	Approved
Α	08.01.23	New Issue	KJ/EC/DD 🦖	



DESIGN PH	DRAWN BY	DART AEROSP HAWKESBURY, ONTARI	
CHECKED :	APPROVED //	DRAWING NO.	REV. A
-	·   th	D3595	SHEET 1 OF 1
DATE	-	TITLE	SCALE
07.02.07		RUBBER CUSHION	NTS
Α	07.02.07	NEW ISSUE	



## SPECIFICATION CONTROL DRAWING



EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

## **NOTES**

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright @ 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.